

## ABSTRACT

An I.S. machine is disclosed wherein the blow molds are held open during a preheat blank mold mode of operation and the neck ring arms of an invert and neck ring assembly are rotated to an acute angle and opened to release held parisons. A cullet chute is defined in the section frame from a location below the invert of the assembly towards the blow molds to collect the parisons which are delivered by a parison deflector.

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